

Shif Jan 20, 2017

Work Order ID 154586

154586

Page 1

Thursday, December 15, 2016 1:28:15 PM

Item ID: D2926-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Web

Start Date: 12/16/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 12/23/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: LS Date: 16/12/15

Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2926	Rev A

100

0.00

100

Skidtubes

0.00

Skidtubes

Memo

1- Cut D2500-3 to length: 98.44"

2- Drill pilot holes and open to size using drill Jig DT8777 as per Dwg D2926

3- Deburr

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

Quality Control

0.00

16-12-19 DT
16-12-19

DAS
03
9-89

Work Order ID 154586***154586***

Page 2

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Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

0.00

HandFinish

Memo

Hand Finishing

130

QC7-Inspect Chemical Conversion Coat

0.00

130

0.00

QC

Memo

Quality Control

140

Identify as per dwg & Stock Location: L6002

0.00

140

0.00

Packaging

Memo

Packaging

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

DAS
21
9-89

DEC 20 2016

DEC 19 2016

Picklist Print

Thursday, December 15, 2016 1:28:19 PM

Page 1

Work Order ID: 154586

154586

Parent Item: D2926-3

D2926-3

Parent Item Name: Web

Start Date: 12/16/2016

Required Date: 12/23/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP B05.05.25 Added drill Jig to step 3; 98.44"" was 89.44""KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

144.0000

1

3

D2500-3-100

16-12-19 JLM

Ext'n -I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

144

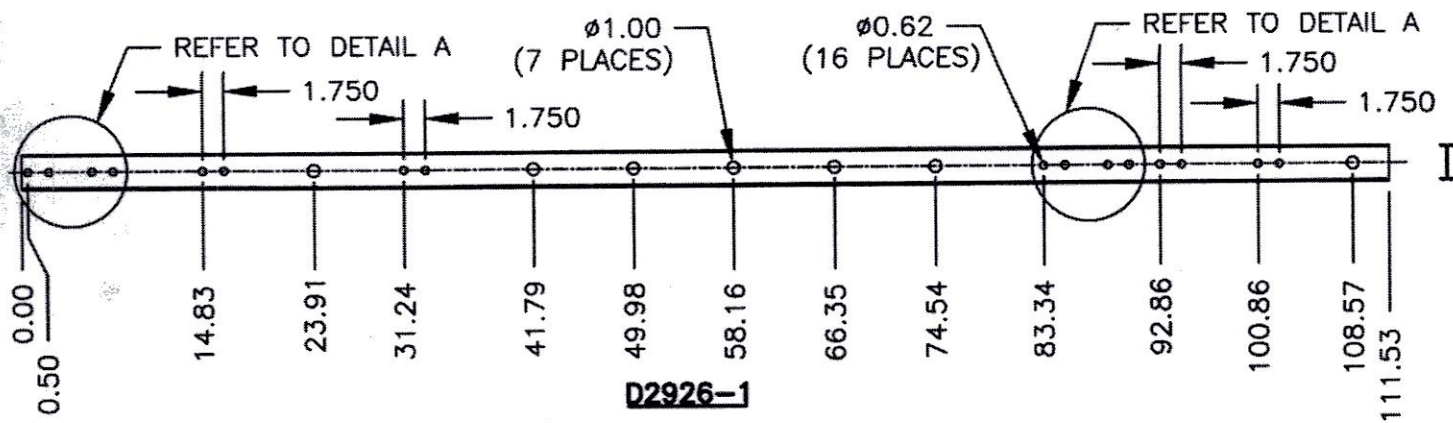
147804

144

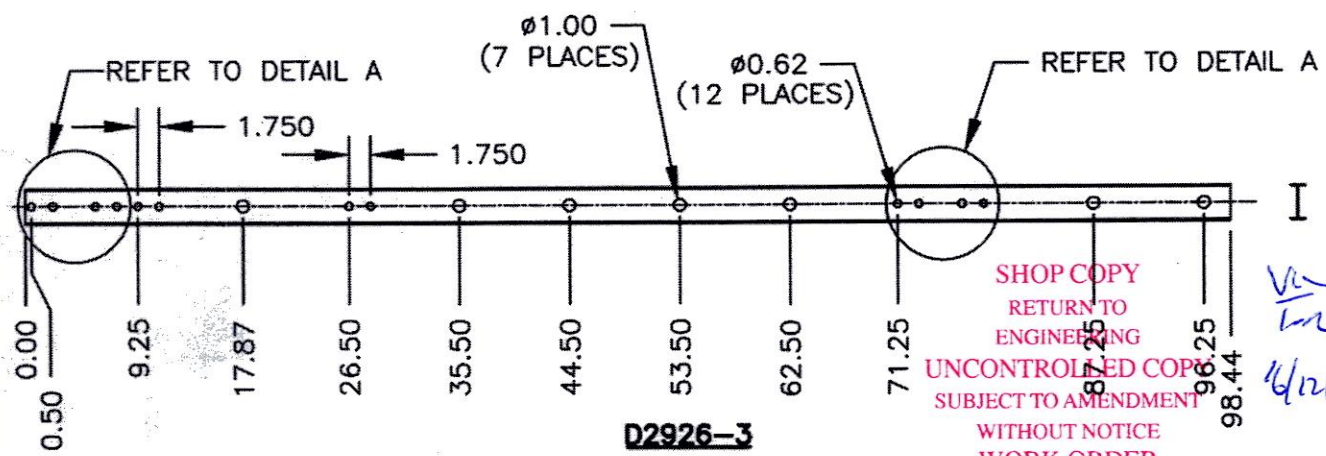
3



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2926
DATE 04.06.22	TITLE WEB	REV. A SHEET 1 OF 1
A	04.06.22	NEW ISSUE



D2926-1

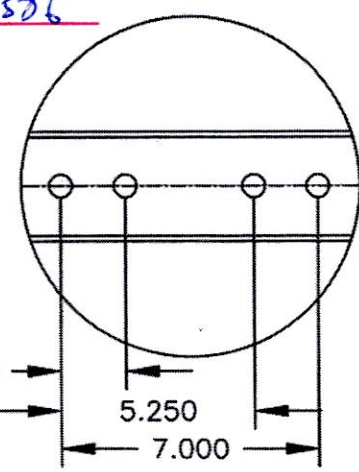


D2926-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154586

✓
Lm
4/2/15

DETAIL A
SCALE 1:5



RELEASED
04.06.25

- GENERAL NOTES:
- 1) MAKE FROM D2500-3 EXTRUSION
 - 2) ALL HOLES ON CENTERLINE
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

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